

Work Order ID 86238

86238

Page 1

June-25-12 10:32:44 AM

Item ID: D3537-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearpad

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/25

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
304 .063	1-Cut as per Dwg D3537Dwg Rev: <u>C</u> if necessary								
	Prog Rev: <u>C</u> 2-Deburr								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

55 0 Jm 12-7-4

55 0 Jm 12-7-4

counter
(+55)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Start Date: 25/06/2012 Start Qty: 50.00 ***50***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 50.00 ***50***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00				55x			12/07/12
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1								
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch/A/R 2059B Hardcoat M122210 Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpadif necessary								
150		0.00							
150	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									

(x55)

MAL 12/07/12

DAS 16

12/07/12

(x55)

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Cust Item ID:

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50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS 16 8-83 12/01/13

cont. AS

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8:30

3200F

9:00

SSX ✓ MZ 12/07/16

M121274

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

SSV & 12/02/16

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: F-PQ 0.00

190

Packaging

Memo

0.00

Packaging

SSX ~~✓~~ mf
12/07/16

200

QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

12/7/18 MS
12/07/16

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Picklist Print

June-25-12 10:32:48 AM

Page 1

Work Order ID: 86238

86238

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

1.5746

0.106

5.578947

M304S16GA

**

Jm 12-7-4

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

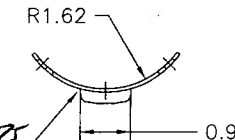
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

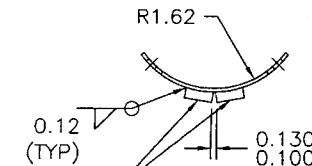
NO. **86238 HJ**

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

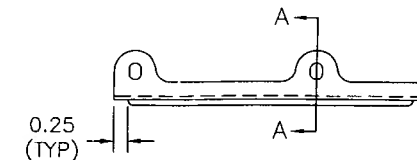
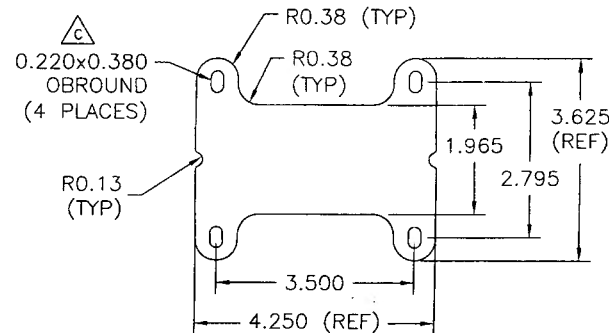
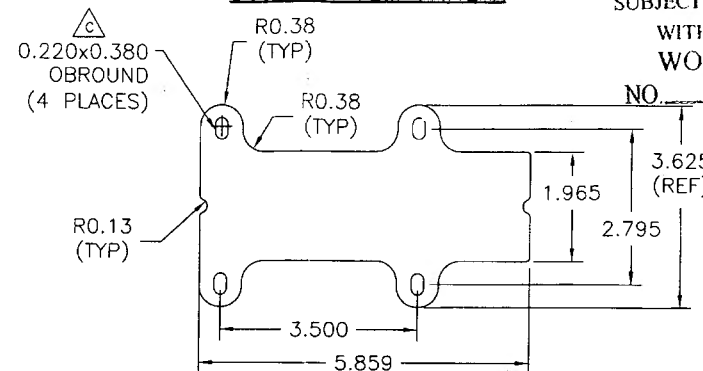
SECTION B-B



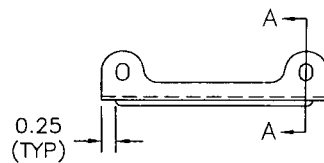
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AB
per ECU
962

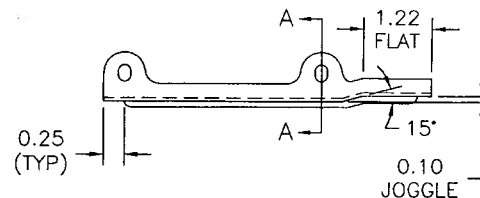
D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)

**D3537-1F FLAT PATTERN****D3537-3F FLAT PATTERN**

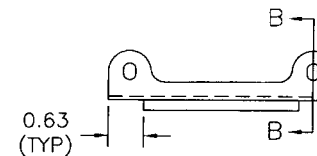
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

**D3537-1/-3/-5/-7 WEARPAD NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.

PORT HADLOCK, MA

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